

Work Order ID 86618

Friday, July 06, 2012 10:12:40 AM

86618

Page 1

Item ID: D4522-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Shaft Arm

Start Date: 7/5/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *12-08-06* Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4522

B

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 1.910"

B.A 12/07/10

2 0

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB112

FOLIO REV: *44*

DWG REV: *B*

mf 12/07/13

2 0

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86618

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Page 2

Item ID: D4522-11

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Handle Shaft Arm

Stop

NS2

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12/07/13

2

2

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

12-7-16

140

Identify as per dwg & Stock Location

0.00

140

Packaging

Memo

0.00

Packaging

2x

12-7-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 10:12:40 AM

Page 1

Work Order ID: 86618
Parent Item: D4522-11
Parent Item Name: Handle Shaft Arm

Start Date: 7/5/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1:000X2.000 303 BAR 1" X 2"		Purchased	No			100	f	23.6667	0.16	0.3368421		LA 12/07/10	

Location

Loc Qty

Loc Code

MAT050

23.6667

121921

11.6667

122245

12

0.3368421

Dart Aerospace Ltd

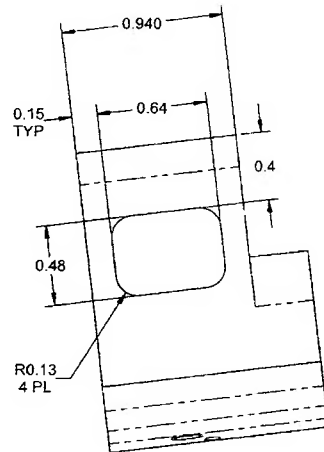
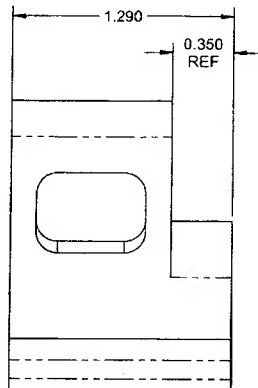
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

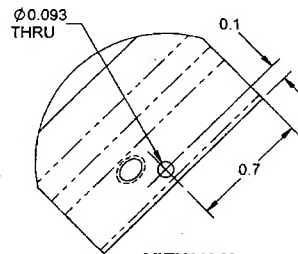
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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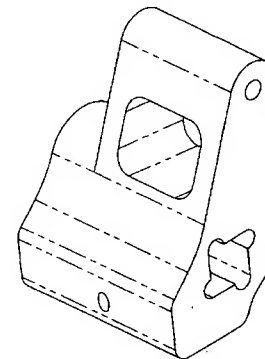
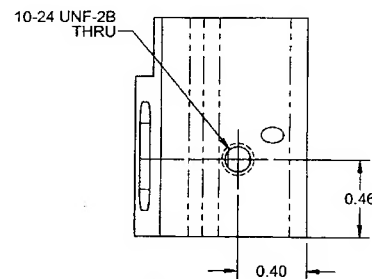
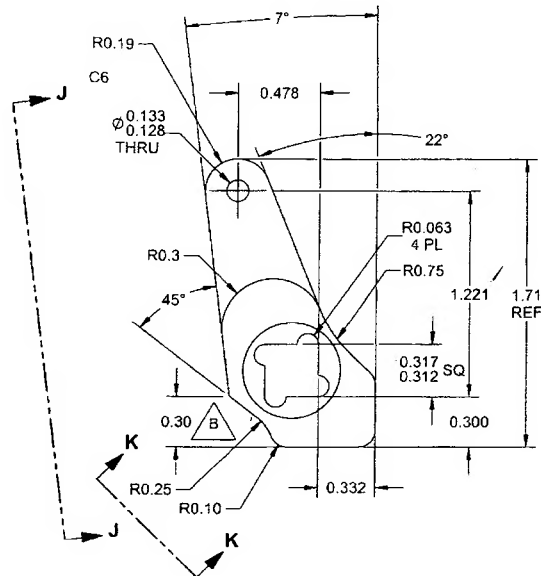
NOTE: Date & initial all entries



VIEW J-J C4



VIEW K-K C4






86616

RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.14 lbs
- 8) PROFILE PER DWG FILE "D4522-11-RevB.STP"

D4522-11 HANDLE SHAFT ARM

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AY	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 14 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86618
Description: HANDLE SHAFT ARM		Part Number: D4522-11
Inspection Dwg: D4522 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.290	$\pm .030$	1.287	—		Vern M-06	
.350	$\pm .010$.347	—		"	
.940	$\pm .010$.940	—		"	
.64	$\pm .030$.640	—		"	
.15	$\pm .030$.150	—		"	
.48	$\pm .030$.475	—		"	
.40	$\pm .000$.400	—		"	
R.13	$\pm .030$	R.125	—		R-6	
.478	$\pm .010$.476	—		Vern M-06	
.332	$\pm .000$.331	—		"	
1.221	$\pm .010$	1.222	—			
1.71	$\pm .030$	1.710	—		"	
.300	$\pm .010$.297	—		"	
.312	$\pm .005$.314	—		"	
Ø.128	$\pm .005$	Ø.128	—		"	
.46	$\pm .030$.452	—		"	
.40	$\pm .030$.400	—		"	
10-24UNF	N/A	—	—		"	
.1	$\pm .100$.100	—		"	
.7	$\pm .000$.689	—		"	
Ø.093	$\pm .001$	Ø.094	—		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 12/07/13	Date: 12.7.16	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15